



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4918-3

Job Sheet 181268



Part No: D4918-3

Job Qty: 6 ea

Part Name: Wearplate Center Fwd



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEET 1 IPP REV:A 13.12.09 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		8/31/18	0.00	0.00	Start Up Waterjet		SC 18/07/31
100	Waterjet	6 pcs		8/31/18	0.00	1.05	Waterjet1		SC 18/07/31
110	QC	6 pcs		8/31/18	0.00	0.00	QC2 Waterjet-1		SC 18/07/31
120	QC	6 pcs		8/31/18	0.00	0.00	QC8-5		18-08-01
130	Brake NC	6 pcs		8/31/18	0.00	0.34	Brake NC 1		18-08-01
140	QC	6 pcs		8/31/18	0.00	0.00	QC5		AUG 16 2018 38
150	SprayPaint	6 pcs		8/31/18	0.00	0.20	Spray Paint		18-08-01 DAS
160	QC	6 pcs		8/31/18	0.00	0.00	QC5		AUG 30 2018 68
170	Packaging	6 pcs		8/31/18	0.00	0.00	Packaging3-2	FP-602	18-08-01 8-89
180	QC21-SA	6 Ea		8/31/18	0.00	0.00	QC21		21 AUG 30 2018 9-89

Part Op 110 - QC2- Inspect parts off machine FAI/FAIB

Descriptions: 120 - QC8- Inspect parts - second check

140 - QC5- Inspect part completeness to step on W/O

160 - QC5- Inspect part completeness to step on W/O

170 - Identify as per dwg & Stock Location: FP-602

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	4.6440 sf (.774 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S20GA	5	371	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.188Inches + 0.005 - 0.001	0.193 0.187	0.192	
2	Wearplate	0.300Inches ± 0.010	0.310 0.290	0.304	
3	Wearplate	0.300Inches ± 0.010	0.310	0.305	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

Description Work Order Deviation

ed By _____
 Supervisor _____
 Coordinator _____
 Approval _____

Part: D4918-3
 Job No: 181268
 Serial No/Batch: S097982
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: Various STC's

Date: 07/31/18

DART AEROSPACE
 Container No: S097982
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 813 832-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Root Cause			
Environment ☐	No Re-verification ☐	Pressure/Force ☐	ed Wrong ☐
Design ☐	Operator ☐	Bending ☐	Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not C ☐	ider tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	orrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	st/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Out of Sequence ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Off-set ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Mislabeled ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Fit/Function ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Misaligned/off center ☐
Past Expiry Date ☐	Manufacturing Process ☐	Drill Holes ☐	Turning Sequence ☐
Misidentified ☐	Past Due ☐	OTHER : _____	

			0.290	
4	Wearplate	2.063Inches $\pm$ 0.010	2.073 2.053	2,068
5	Wearplate	2.813Inches $\pm$ 0.010	2.823 2.803	2,817
6	Wearplate	33.750Inches $\pm$ 0.010	33.760 33.740	33,75
7	Wearplate	5.625Inches $\pm$ 0.010	5.635 5.615	5,629
8	Wearplate	37.130Inches $\pm$ 0.030	37.160 37.100	37,13
9	Wearplate	0.040Inches $\pm$ 0.010	0.050 0.030	0,036

Plex 7/24/18 10:04 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
							Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐																		